

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023179**Date Inspected:** 29-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** John Pagliero**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 10W 11W Longitudinal Stiffener #3 R1
2. 9W 10W D (outside)
3. 9W 10 W PP85 W2 Diverter Bars

1. 10W 11W Longitudinal Stiffener #3 R1

The QA Inspector noted the dimensions of the excavation for the R1 as 19mm's deep 20mm's wide and y=130mm's – 270mm's. Prior to welding, the QC Inspector John Pagliero verified the pre-heat temperature as 200 degrees and welding commenced. The QA Inspector periodically observed the in process Shielded Metal Arc Welding (SMAW) being performed in the 3G vertical position by ABF welder Xiao Jian Wan. The QC inspector was present in order to monitor the progress and ensure the welding parameters were within the established Welding Procedure Specification (WPS). The work continued throughout the QA inspector's shift. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

2. 9W 10W D (outside)

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The QA Inspector noted and periodically observed ABF welding operators Jimmy Zhen and Song Tao Huang performing Flux Core Arc Welding w/gas (FCAW-G) operations on face D outside of the OBG. The QA Inspector observed the QC inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work appeared to be progressing in general conformance with the contract documents.

3. 9W 10 W PP85 W2 Diverter Bars

The QA Inspector periodically monitored the in process SMAW of a 990mm Diverter Bar in the 1G Flat position performed by ABF Welder Fred Kaddu. The QA Inspector observed the QC inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work progressed throughout the QA Inspector's shift. Upon completion The QA Inspector noted that the work appeared to be progressing in general conformance with the contract documents.

Summary of Conversations:

As noted above



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Frey,Doug | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
